

Work Order ID 82602

82602

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April-03-12 11:28:28 AM

Item ID: D2872-045
 Revision ID:
 Item Name: Nut Plate Assembly
 Start Date: 03/04/2012 Start Qty: 10.00
 Required Date: 17/04/2012 Req'd Qty: 10.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: MLJ Date: 12/04/03 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2872	Rev A								
100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 0.750" x 0.375" x 2.700" long								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA550 and Dwg D2872 Identify as D2872-5 Dwg Rev <u>A</u> Folio Rev <u>AA</u>								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

and 12/04/06

PO/BA 12/04/08

PO/BA 12/04/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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April-03-12 11:28:29 AM

Item ID: D2872-045
Revision ID:
Item Name: Nut Plate Assembly

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 03/04/2012 Start Qty: 10.00 ***10***
Required Date: 17/04/2012 Req'd Qty: 10.00 ***10***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
140 *140* Small Fab Small Fab	Small Fab Memo 1-Deburr 2- C'sink as per Dwg D2872	0.00 0.00							
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

Re 12.4.9 10 4

10X

4/12/04/10

410

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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April-03-12 11:28:29 AM

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Setup Start ***NS1***

Stop ***NS2***

Start Date: 03/04/2012 Start Qty: 10.00 ***10***

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 10.00 ***10***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00				10	BR	12.4.11	
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00				10X	✓		M/L 12/04/11
Quality Control									
180	Small Fab	0.00							
180									
Small Fab	Memo	0.00				10x	✓		EB 12/04/11
Small Fab	1-Assemble as per Dwg D2872 2-Identify as D2872-045								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:
Item Name: Nut Plate Assembly

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N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 03/04/2012 Start Qty: 10.00 ***10***
Required Date: 17/04/2012 Req'd Qty: 10.00 ***10***

Cust Item ID:


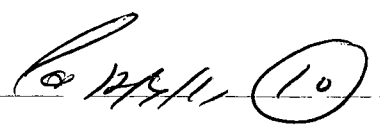
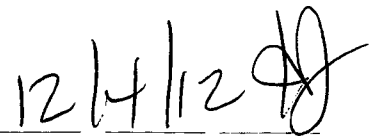
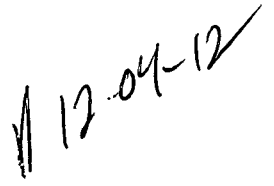
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>019</u> Memo	0.00 0.00							
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-03-12 11:28:33 AM

Page 1

Work Order ID: 82602

82602

Parent Item: D2872-045

D2872-045

Parent Item Name: Nut Plate Assembly

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21086L5 *MS21086L 5* Nut Plate		Purchased	No			100	Each	84.0000	2	20		12/04/11	

**

Location

Loc Qty

Loc Code

ST303

84

102380

34

102728

50

M6061T6B0.375X00.75
0

Purchased

No

180

f

28.1500

0.225

2.368421

M6061T6B0 375X00 750

6061T6 BAR .375 x .750

**

Location

Loc Qty

Loc Code

MAT001

28.15

113719

8.15

117653

20

MS20426AD4-5

Purchased

No

180

Each

5,022.000

4

40

MS20426AD4-5

Rivet

**

Location

Loc Qty

Loc Code

ST317

5022

6874

5022

40

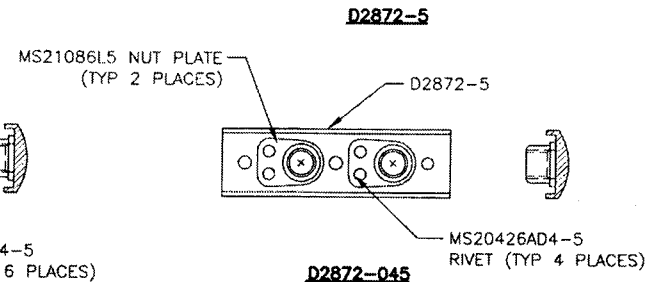
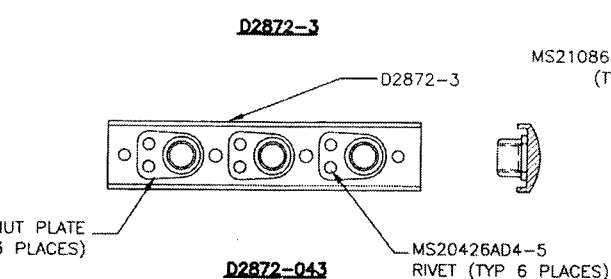
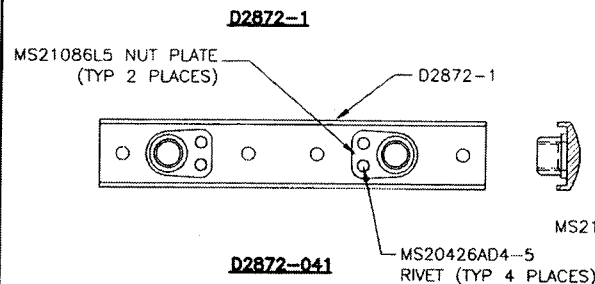
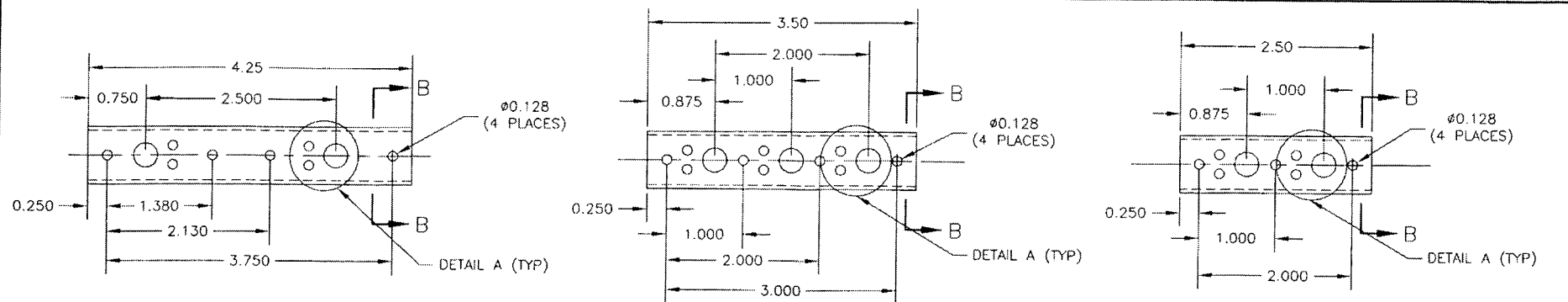
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2872-1/-3/-5 RADIUS BLOCK

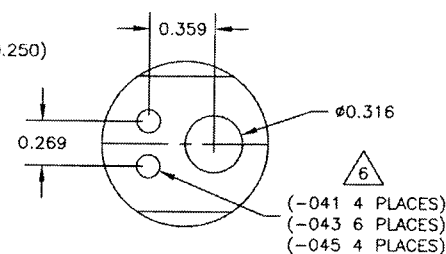
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B0.750X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B0.750X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) $\phi 0.128$ PILOT + C'BORE CURVED SIDE $\phi 0.230 \times 0.050$ DEEP + C'SINK CURVED SIDE $\phi 0.225 \times 100'$

D2872-041/-043/-045 NUT PLATE ASSEMBLY

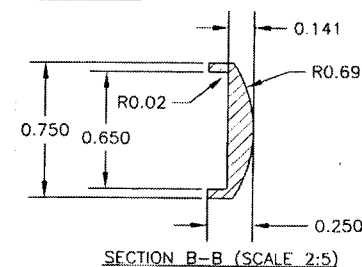
- 1) INSTALL MS21086L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-5 RIVETS

D2872-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2872-041	NUT PLATE ASSEMBLY
	X		D2872-043	NUT PLATE ASSEMBLY
		X	D2872-045	NUT PLATE ASSEMBLY
1			D2872-1	RADIUS BLOCK
	1		D2872-3	RADIUS BLOCK
		1	D2872-5	RADIUS BLOCK
4	6	4	MS20426AD4-5	RIVET
2	3	2	MS21086L5	NUT PLATE



DETAIL A (SCALE 2:5)



SECTION B-B (SCALE 2:5)

RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN	PH	DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED	PH	DART AEROSPACE LTD
DATE	05.07.26	RADIUS BLOCK

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82602 MCT

12/04/03

DART AEROSPACE LTD		Work Order: 82607
Description: NUT PKTR		Part Number: D7872-5
Inspection Dwg: D7872 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+0.030	2.501	✓		VERN	PHD-01
1.000	±0.010	1.000	✓		"	"
0.875	±0.010	0.875	✓		"	"
0.250	±0.010	0.250	✓		"	"
1.000	±0.010	1.000	✓		"	"
2.000	±0.010	2.000	✓		"	"
Ø 0.128	+0.005 -0.001	0.128	✓		"	"
0.359	±0.010	0.358	✓		"	"
0.269	±0.010	0.269	✓		"	"
Ø 0.316	+0.005 -0.001	0.316	✓		"	"
0.141	±0.010	0.138	✓		"	"
0.750	±0.010	0.751	✓		"	"
0.650	±0.010	0.646	✓		"	"
0.250	±0.010	0.250	✓		"	"
Ø 0.230 x 0.050	+0.005 -0.001 x 0.010	0.230 x 0.051	✓		"	"

Measured by: PO/B.A	Audited by: DR	Preliminary Approval:
Date: 12/04/08	Date: 12.4.9	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15